

Work Order ID 109902

December-05-13 11:07:32 AM

\*109902\*

Rec'd. 5/16/28  
PRELIMINARY ISSUE

Page 1

Item ID: D3676-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bubble Window, LH

Start Date: 12/05/13 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 12/06/13 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals: Process Plan: *V*

Date: 12-05-13 Tooling:

Date:

Run Start \*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3676

Rev C *D*

100

0.00

\*100\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Set up Machine as per folio ETA 018 and D3676 program

*x-3*

*Sh*  
13/11/24

110

0.00

\*110\*

HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks to 38" by 52"

*x3*

*Sh*  
13/11/24



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Page 2

Item ID: D3676-1 Accept \*N9000040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Bubble Window, LH  
 Start Date: 12/05/13 Start Qty: 3.00 \*3\* Cust Item ID:  
 Required Date: 12/06/13 Req'd Qty: 3.00 \*3\* Customer:  
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start \*NR1\*  
 QC: Date: SPC (Y/N): Date: Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

\*120\*

Thermoform

Thermoforming Machine

THERMOFORMING MACHINE

Memo

Thermoform as per Dwg. D3676 and Folio FTA 018

Dwg. Rev. \_\_\_\_\_

Folio Rev. C

- 1- Visually inspect for proper formation of each part
- 2-Check depth of bubble

0.00

0.00

x3

13/11/14

150

\*150\*

Thermoform

Thermoforming Machine

HAND FINISHING THERMOFORMING

Memo

- 1) Trim off excess flange material
- 2) Buff out any light scratches or blemishes
- 3) Etch part number and batch number

0.00

0.00

x3

14/02/12





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Page 3

Item ID: D3676-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bubble Window, LH

Start Date: 12/05/13 Start Qty: 3.00

\*3\*

Cust Item ID:

Required Date: 12/06/13 Req'd Qty: 3.00

\*3\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC2- Inspect parts off machine FAI/FAIB

0.00

\*160\*

QC

Memo

0.00

Quality Control

14/02/12

170

QC5- Inspect part completeness to step on W/O

0.00

\*170\*

QC

Memo

0.00

Quality Control

1) Visually inspect for clarity, and proper formation.

11/3/4

2

180

Identify as per dwg & Stock Location:

0.00

\*180\*

Packaging

Memo

0.00

Packaging

5/184

12/4/3/4 (2)

DAS  
27  
9-09

Release

POSITIVE RECALL

EFFECTIVE

12/12/05

RELEASED

AUTH

DATE

Rev. on per  
Rev D



# Work Order ID 109902

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\*109902\*

Page 4

Item ID: D3676-1

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Bubble Window, LH

Start Date: 12/05/13 Start Qty: 3.00 \*3\*

Cust Item ID:

Required Date: 12/06/13 Req'd Qty: 3.00 \*3\*

Customer:

Reference:

Run Start \*NR1\*

Approvals: Process Plan: Date: Tooling: Date:

Stop \*NR2\*

QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC21- Final Inspection - Work Order Release

0.00

\*190\*

QC

Memo

0.00

Quality Control

PL 14-03-4

① 14-03-04





# Picklist Print

December-05-13 11:07:32 AM

Page 1

Work Order ID: 109902

Parent Item: D3676-1

Parent Item Name: Bubble Window, LH

Start Date: 12/05/13

Required Date: 12/06/13

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev A New Product 01/24/2008 DL Verified:JLM  
IPP Rev B Change Mat. to .236"" 08/29/2008 DL

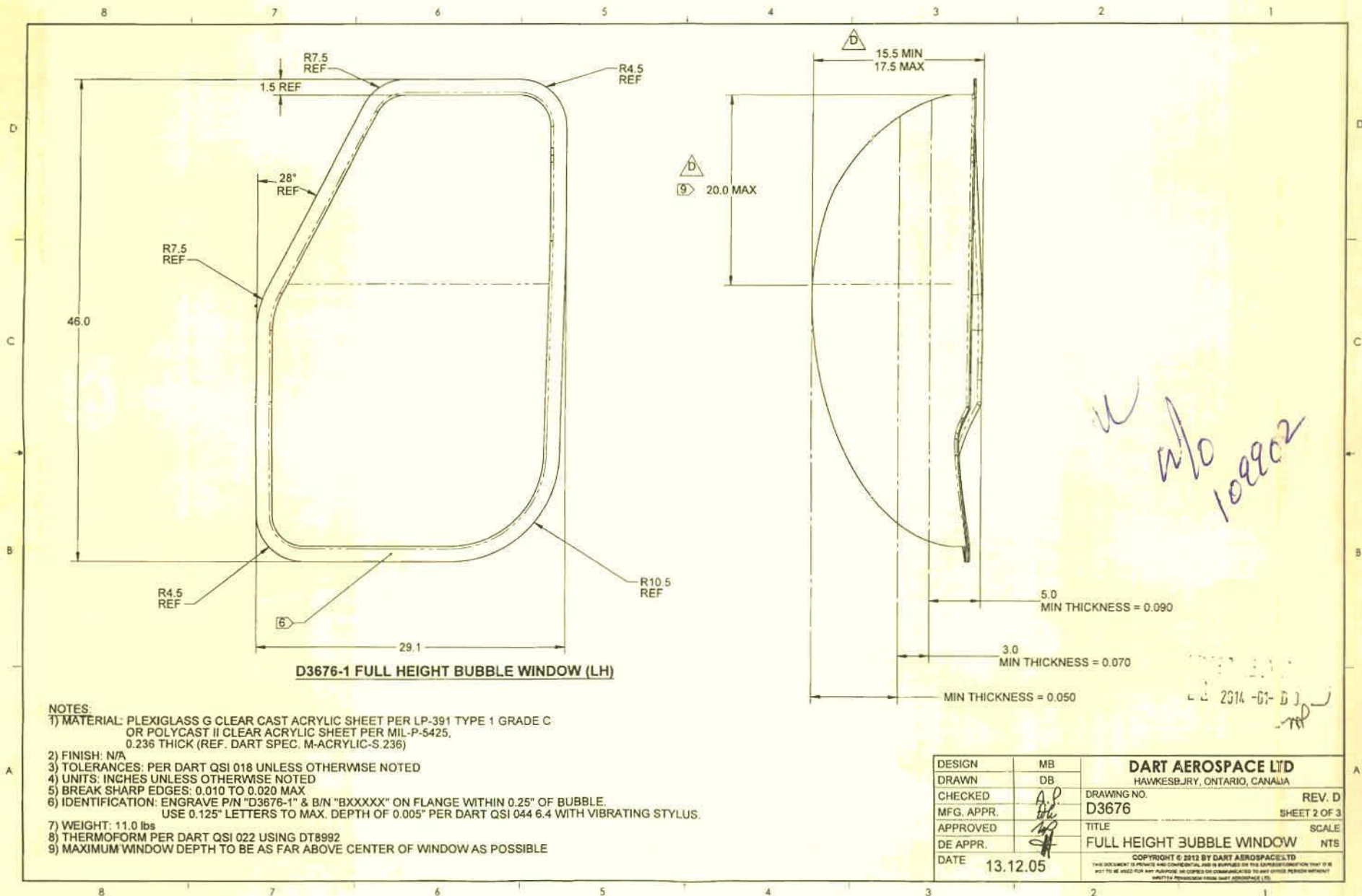
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.236 Plexiglass G .236"		Purchased	No			110	sf	200.0000	14	74			

Location	Loc Qty	Loc Code
MAT	160	
M127669	160	
therm	40	
M127574	40	

OK  
13/13/05.

40 sq ft.

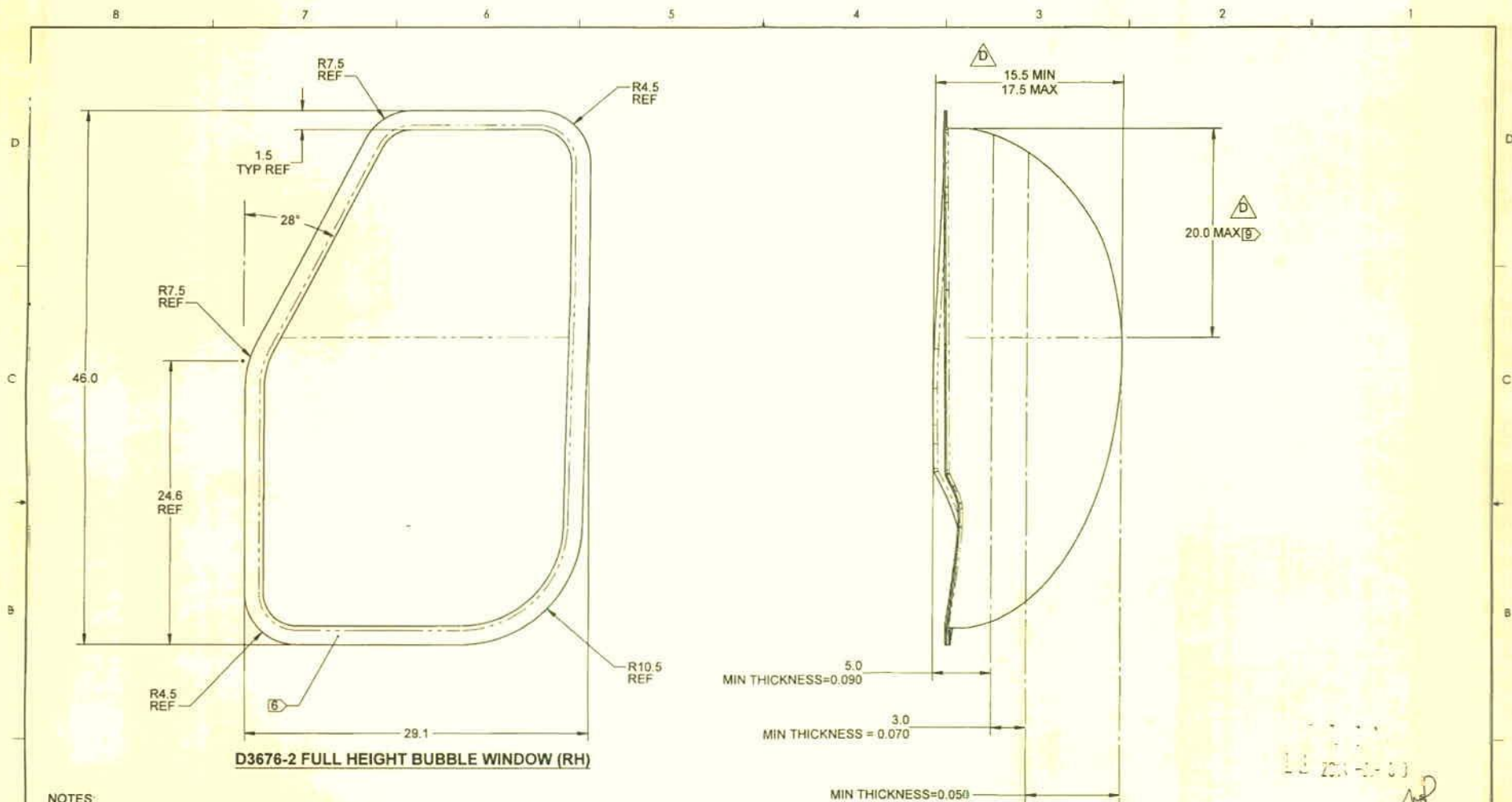




DESIGN	MB	<b>DART AEROSPACE LTD</b>	
DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>A.P.</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>DB</i>	D3676	SHEET 2 OF 3
APPROVED	<i>DB</i>	TITLE	SCALE
DE APPR.	<i>DB</i>	FULL HEIGHT BUBBLE WINDOW	NTS
DATE	13.12.05	COPYRIGHT © 2012 BY DART AEROSPACE LTD	
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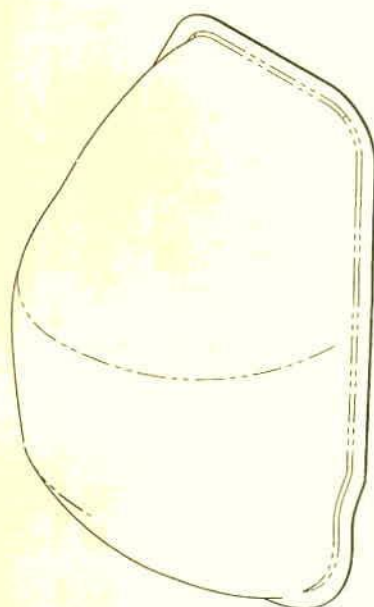
**D3676-2 FULL HEIGHT BUBBLE WINDOW (RH)**

**NOTES:**

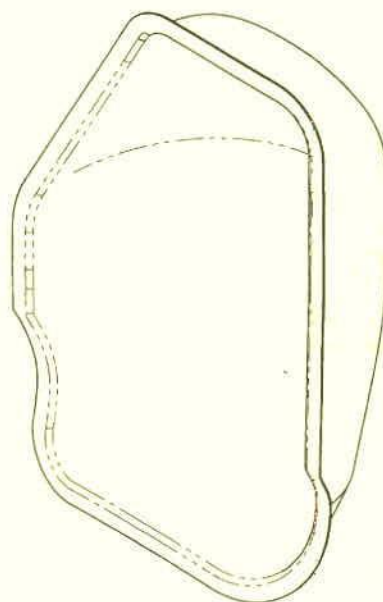
- 1) MATERIAL: PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391 TYPE 1 GRADE C OR POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425, 0.236 THICK ( REF. DART SPEC. M-ACRYLIC-S.236)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
- 6) IDENTIFICATION: ENGRAVE P/N "D3676-2" & B/N "BXXXXX" ON FLANGE WITHIN 0.25" OF BUBBLE. USE 0.125" LETTERS TO MAX. DEPTH OF 0.005" PER DART QSI 044 6.4 WITH VIBRATING STYLUS.
- 7) WEIGHT: 11.0 lbs
- 8) THERMOFORM PER DART QSI 022 USING DT9794
- 9) MAXIMUM WINDOW DEPTH TO BE AS FAR ABOVE CENTER OF WINDOW AS POSSIBLE

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DRAWN	DB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	DE	D3676	SHEET 3 OF 3
APPROVED	DE	TITLE	SCALE
DE APPR.	DE	FULL HEIGHT BUBBLE WINDOW	NTS
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**D3676-1 FULL HEIGHT BUBBLE WINDOW (LH)**



**D3676-2 FULL HEIGHT BUBBLE WINDOW (RH)**

REV.	DESCRIPTION	BY	DATE
D	UPDATE TOLERANCE ON DEPTH, ADD 20.0 MAX. VERTICAL DIMENSION (SH 2 & 3), NEW VIEW LAYOUTS ON SH 1 & 2	DB	13.12.05
C	ADDED D3676-2 FULL HEIGHT BUBBLE WINDOW (RH). REMOVED NOTES ON SHEET 1, REFORMAT NOTES 6 & 8 ON SHEET 2. D3676-1 WAS "412 BUBBLE WINDOW" NOW "FULL HEIGHT BUBBLE WINDOW (LH)".	AP	12.03.01
B	REVISED TOLERANCE ON MINIMUM THICKNESSES (ZN AS/25-2). REASON: PRODUCTION FACILITY	MB	08.10.27
A	NEW ISSUE	MB	08.02.29
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DRAWN	DB		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	DB	D3676	SHEET 1 OF 3
APPROVED	MB	TITLE	SCALE
DE APPR.	MB	FULL HEIGHT BUBBLE WINDOW	NTS
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